

Work Order ID **76210**

76210

Page 1

November-07-11 2:37:27 PM

Item ID: D3195-043

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket Assembly

Start Date: 07/11/2011 Start Qty: 6.00

6

Cust Item ID:

Required Date: 21/11/2011 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 11/11/08

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3195	Rev A								

100

0.00

100

BAND SAW

11/12/13

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: (1.250" x 1.500") x 3.60" long

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

CZ 11/12/14 10

HAAS 1 Jeaspa

Memo

0.00

HAAS CNC vertical machine #1

1-Machine D3195-3 as per Folio FA334 and Dwg D3195 Identify as D3195-32-Deburr

Machine as per dwg D3195 REV. A

issue P/O to Archer.

P/O: 15679

120

0.00

120

QC rec'd.

Memo

0.00

Quality Control

rec'd + inspect for transit damage.
attached CQC to W/O

11/14/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76210

76210

Page 2

November-07-11 2:37:27 PM

Item ID: D3195-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket Assembly
 Start Date: 07/11/2011 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 21/11/2011 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC Inspect parts - second check Memo	0.00 0.00		8126261		(410)			
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							10 BR 12-2-1
150 *150* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo	0.00 0.00							10X PM-L 12/02/02

START TIME: 1:50 FINISH TIME: 2:20
 OVEN TEMPERATURE:
 W48489 32001

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 Start Date: 07/11/2011 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 21/11/2011 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Small Fab	0.00							
170									
Small Fab	Memo 3M 1300/1300L Neoprene High Performance	0.00							
Small Fab	1-Lightly Sand bonding surface2-Bond D3195-7 into D3195-13as per Dwg D3195A/RContact Cement M12-159								
	S212121 + Lable with Perm mark marker P/W + B.								
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.00							
Quality Control									

10 BL 1222

ES 12/02/03 (10)

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Page 4

November-07-11 2:37:27 PM

Item ID: D3195-043 Accept ***N900040100*** Setup Start ***NS1***
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 Item Name: Bracket Assembly
 Start Date: 07/11/2011 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 21/11/2011 Req'd Qty: 6.00 ***6*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <u>ST24</u>	0.00							
190									
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

(10x) SP 12-02-06

12/2/6 JA

12-06-2
(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

November-07-11 2:37:31 PM

Work Order ID: 76210

76210

Parent Item: D3195-043

D3195-043

Parent Item Name: Bracket Assembly

Start Date: 07/11/2011

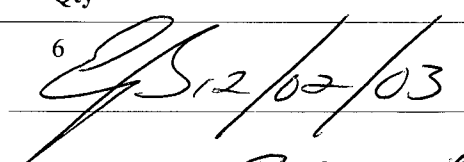
Required Date: 21/11/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 05-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3195-7 Pad		Manufactured	No			100	Each	10.0000	1	6			
										**			

				Location	Loc Qty	Loc Code							
				GA	10								
				73040	10								
M6061T6B1.500X01.25 0		Purchased	No			170	f	24.1120	0.3	1.894737			

M6061T6B1-500X01-250

6061-T6 Bar 1.50 x 1.25

Location	Loc Qty	Loc Code		
MAT004	24.112			
118071	0.112			
119513	24			
			1.9	11/12/13

D3195-3P

X10



B79044 (6x)
B79768 (4x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

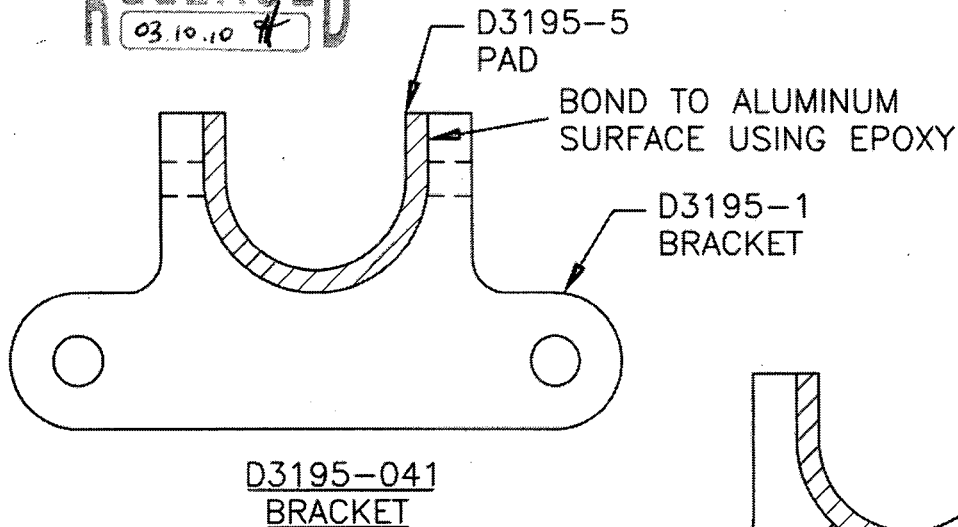
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



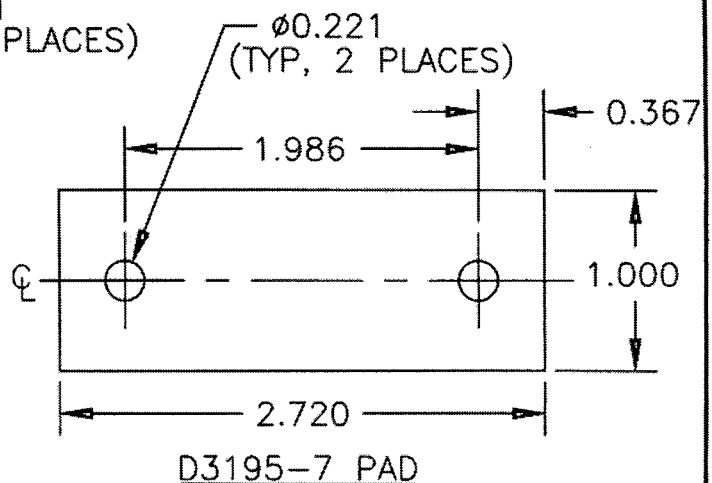
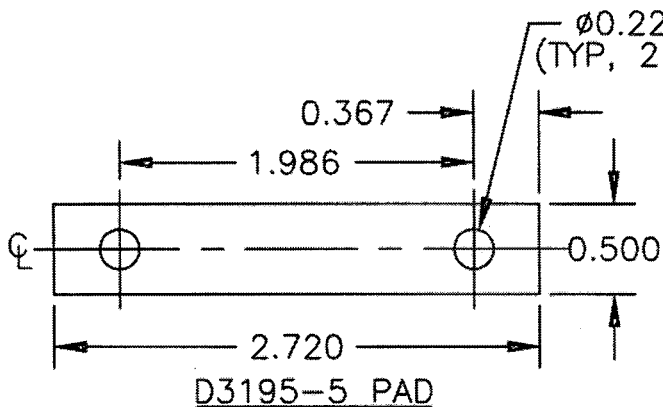
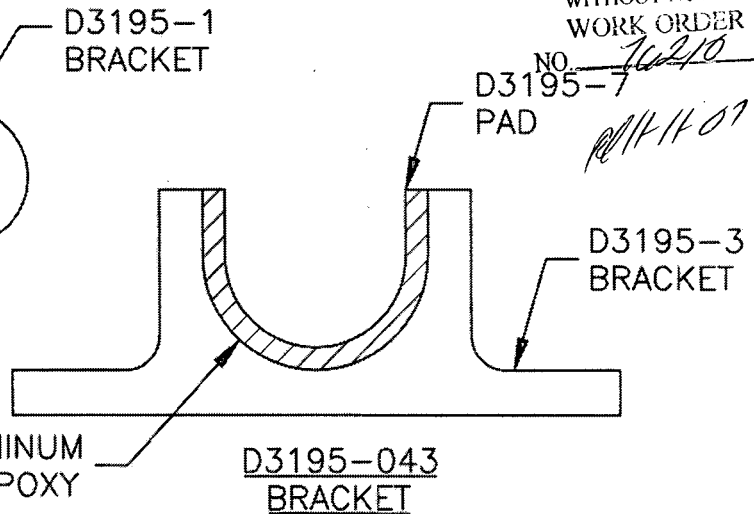
DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3195	REV. A SHEET 1 OF 3
DATE 03.06.23		TITLE BRACKET	SCALE 1:1
A	03.06.23	NEW ISSUE	

RELEASED
03.10.10 *#*



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. *76210*
11/11/07



D3195-5 & D3195-7 PAD

- 1) MATERIAL: 60 DUROMETER NEOPRENE 1/8" THICK
(POSSIBLE SUPPLIERS, ACCURATE RUBBER)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 3) ALL DIMENSIONS ARE IN INCHES

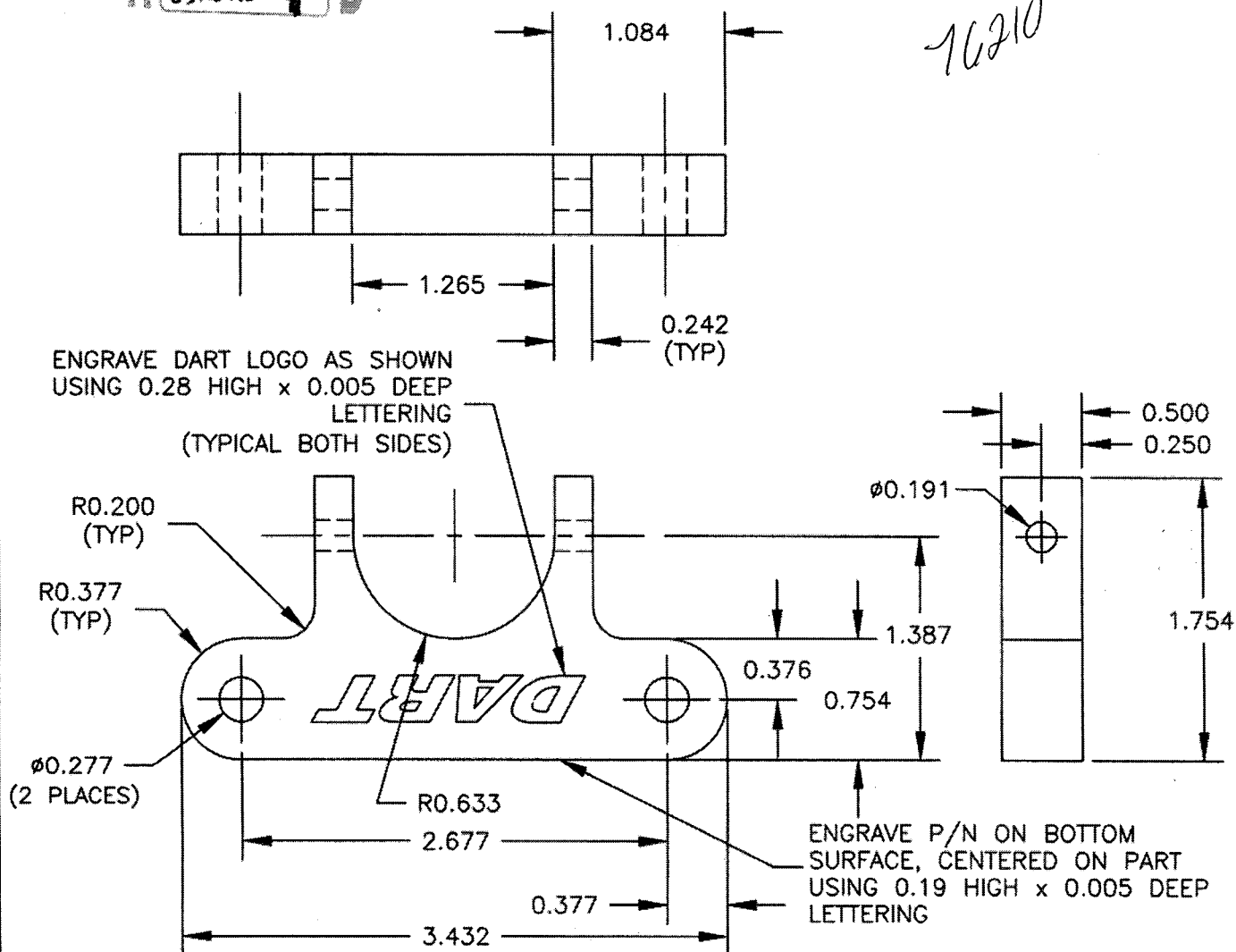
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3195	REV. A SHEET 2 OF 3
DATE 03.06.23		TITLE BRACKET	SCALE 1:1

RELEASED
03.10.10



D3195-1 BRACKET

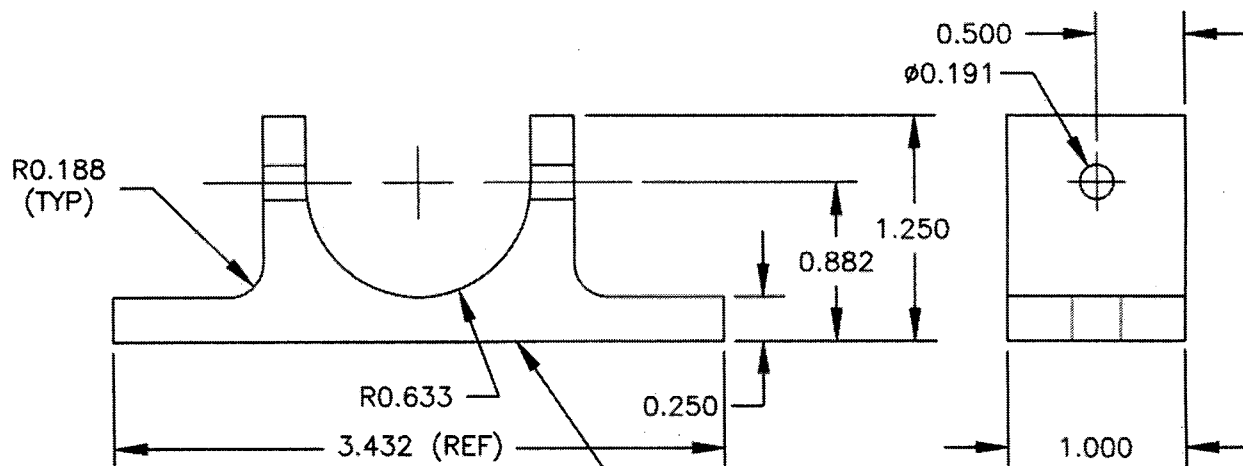
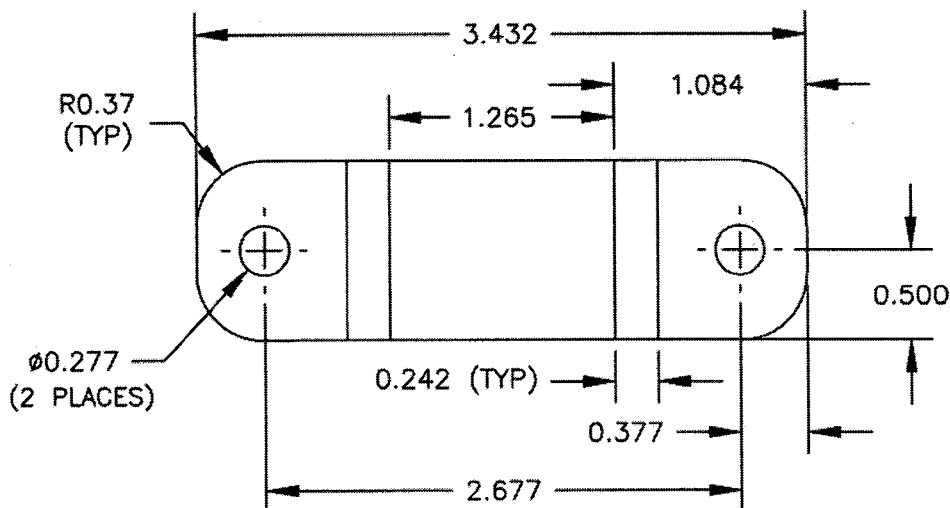
- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3195	REV. A SHEET 3 OF 3
DATE 03.06.23		TITLE BRACKET	SCALE 1:1



RELEASED
03.10.10

ENGRAVE P/N ON BOTTOM
SURFACE, CENTERED ON PART
USING 0.19 HIGH x 0.005 DEEP
LETTERING

D3195-3 BRACKET

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO15679

Purchase Order Date 12/14/11

PO Print Date 1/20/12

Page Number 1 of 3

Order From : VC-GLO001

ARCHER PRECISION INC.
36 COLONNADE RD. N.
NEPEAN, ON K2E 7J6
CA

Contact Name
Vendor Phone 613 226 1579
Vendor Fax 613 226 1719
Vendor Account Nbr

Buyer Chantal Lavoie
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

RECEIVED

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
	D3195-1P	Bracket	1/27/12 Yes	10.00 Each	Yours ppd	\$33.8200	\$338.20
		Special Inst:	AS PER DWG D3195 REV. A B76209 MATERIAL SUPPLIED BY DART				
	D3195-3P	Bracket	1/27/12 Yes	10.00 Each	Yours ppd	\$33.8200	\$338.20
		Special Inst:	AS PER DWG D3195 REV. A B76210 MATERIAL SUPPLIED BY DART				
	D4108-7P	Bracket	1/27/12 Yes	6.00 Each	Yours ppd	\$57.6300	\$345.78
		Special Inst:	AS PER DWG D4108 REV. A B76873 MATERIAL SUPPLIED BY DART				
	D3137-3P	Guide	1/27/12 Yes	20.00 Each	Yours ppd	\$26.6600	\$533.20

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 3

Change Date: 1/20/12

Phone # 613-899-2405

Packing Slip

Date	Invoice #
1/24/2012	32

Ship To
Main Finished Goods Location Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7

P.O. No.	Ship	Via	FOB	Project
15679	1/24/2012			

Qty	Item Code	Description
10	Sales	D3195-3 Bracket
20	Sales	D3137-3 Guide
		HST (ON) on sales
		8/12/02/01



1393 Major Road
Orleans, Ontario
K1E 1H3

Telephone (613) 899-2405
Fax (613) 226-1719

Certificate of Compliance

To:
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury Ont.
K6A 1K7

Po Number	Part Number	Quantities
15679	D3137-3	20
	D3195-3	10

It is hereby certified that all articles mentioned above are in conformance with the requirements, specification and drawings as listed on customer purchase order number, 15625 issued by Dart Aerospace Inc.

A handwritten signature in dark ink, appearing to read "Alex Mazzeroffe", is written over a horizontal line.

Alex Mazzeroffe
President
Archer Precision Inc.
1393 Major Road,
Orleans Ontario
K1E 1H3